



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2858-1

Job Sheet 185558



Part No: D2858-1

Job Qty: 10 ea ^{DAS}

Part Name: Hinge Bracket



24 ea ²¹
3-89

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-1		DTP 18-11-05
100	Bandsaw	10 pcs	11/9/18	11/9/18	0.00	0.05	Bandsaw1		DTP 18-11-05
110	CNC Vertical Machining	10 pcs	11/9/18	11/9/18	0.11	2.79	HAAS1-2		DTP 18-11-05
130	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-1		mm 18/11/08
140	HandFinish	10 pcs	11/9/18	11/9/18	0.00	0.11	HandFinish1		DR 18/11/08
150	Powdercoat	10 pcs	11/9/18	11/9/18	0.00	0.13	Powdercoat1		3-89 11-09
160	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC3		DAS 38
170	Packaging	10 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		6 NOV 15 2018
180	QC21-SA	10 Ea	11/9/18	11/9/18	0.00	0.00	QC21		2-89 11-09

Part Op 110 - 1-Machine per folio FA941
Descriptions: 150 - START TIME:

cut Blank at 5,850" * 1 Blank makes 3 parts *
M 185559 START: 9:20 O.T.: 3:00 FINISH: 9:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X1.250	6061-T6 Bar 1.50 X 1.25	1.6300 ft (.163 ea)	90-Start up Operation	EM 137980-85

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X1.250	2	7	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.171inches + 0.005 - 0.001	0.176 0.170	0.171	
2	Hinge Bracket	0.400inches + 0.006 - 0.001	0.406 0.399	0.400	
3	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	0.125	
4	Hinge Bracket	0.328inches ± 0.010	0.338 0.318	0.328	
5	Hinge Bracket	0.820inches ± 0.005	0.825 0.815	0.820	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				situation																					
DART Aerospace Ltd. 1270 Aberdeen Street Newkensbury, ON K8A 1K7 CANADA TEL: 519 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S124487 Part: D2858 - 1 Job No: 185558 Serial No/Batch: S124487 Revision: C Inspector: _____ Exp Date: _____ Instructions: Various STC's				Date: 11/05/18																					
				Completed By																					
				Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																					

Root Cause							
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐		Operator ☐		Bending ☐		Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Weld ☐	Part Incorrect ☐
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐		Use for Testing ☐		Cuffs ☐		Out of Sequence ☐	Part Moved ☐
Internal Transport ☐		Poor Information ☐		Crushing ☐		Off-set ☐	Drawing ☐
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Mislabeled ☐	Finish ☐
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Fit/Function ☐	Misread ☐
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐		Manufacturing Process ☐					
Misidentified ☐		Past Due ☐		OTHER : _____			

6	Hinge Bracket	1.476inches $\pm$ 0.010	1.486 1.466	1.476
7	Hinge Bracket	0.342inches $\pm$ 0.010	0.352 0.332	0.342
8	Hinge Bracket	0.875inches $\pm$ 0.005	0.880 0.870	0.874
9	Hinge Bracket	1.560inches $\pm$ 0.030	1.590 1.530	1.562
10	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137	0.154
11	Hinge Bracket	0.717inches $\pm$ 0.010	0.727 0.707	0.718
12	Hinge Bracket	0.697inches $\pm$ 0.010	0.707 0.687	0.697
13	Hinge Bracket	0.229inches $\pm$ 0.010	0.239 0.219	0.232
14	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	0.125
15	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	0.063
16	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	0.064
17	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116	0.1245
18	Hinge Bracket	0.630inches $\pm$ 0.010	0.640 0.620	0.633
19	Hinge Bracket	0.354inches $\pm$ 0.010	0.364 0.344	0.353
20	Hinge Bracket	0.965inches $\pm$ 0.010	0.975 0.955	0.967
21	Hinge Bracket	0.166inches $\pm$ 0.005 - 0.000	0.171 0.166	0.167
22	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	0.130
23	Hinge Bracket	32.700Degrees $\pm$ 0.500	33.200 32.200	32.7°

DTP 18-11-4
201.

Plex 10/30/18 11:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



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Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
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